

Work Order ID 64566

Wednesday, December 08, 2010 10:27:24 A



Page 1

Item ID: D3805-045

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate Assembly Aft, Low Gear

Start Date: 12/8/2010 Start Qty: 6.00

Required Date: 12/22/2010 Req'd Qty: 6.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

*PA*Date: *12-12-8*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3805

Rev A

100

0.00



Large Fab

Memo

0.00

Large Fab

1- on D3806-5, fill cut outs with hardcoat welding rod as per dwg D3805

2059 B Hardcoat Welding Rod

BATCH#: *M117232*

2-weld D3806-5 to wearplate by positioning holes together as per dwg D3805

304 S.S. Welding Rod

BATCH#: *M107051*

3-Transfer drill holes in bar

EL 11-5-10 (X6)

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

Pl 11-05-10 (X6)

W/O:		WORK ORDER CHANGES					
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Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Euler/11

XB

Quality Control

130

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

2:45
320°F
3:15

6X Ø m/d 11/05/11

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

6 BK 11-5-12

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150

0.00



Small Fab

Memo

0.00

Small Fab

1- Bond D3807-5 gasket to inner surface of wearplate using a thin layer of 3m
1300/1300L scotch grip adhesive as per dwg
BATCH: M115230

8 11/5/16

6

160

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

8 11/5/16

46

170

0.00



Packaging

Identify as per dwg & Stock Location: FP

Memo

0.00

Packaging

11/5/17 60 SP

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/18

MF
11-05-17

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Picklist Print

Wednesday, December 08, 2010 10:27:28 AM

Page 1

Work Order ID: 64566

Parent Item: D3805-045

Parent Item Name: Wearplate Assembly Aft, Low Gear








Start Date: 12/8/2010

Required Date: 12/22/2010

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 08-12-01 new issue EC verified by:DD IPP Rev:B 09-03-04 rev.a as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3805-5  Plate	X	Manufactured	No			100	Each	0.0000	1	6			
					64570x6							EL 11-5-10	
D3806-5  Bar	X	Manufactured	No			100	Each	2.0000	1	6			
												EL 11-5-9.	
					<u>Location</u>				<u>Loc Qty</u>			<u>Loc Code</u>	
					67838 ^{WA} X 6				2				
					46781				2				
D3807-5  Gasket		Manufactured	No			150	Each	0.0000	1	6			
					B 648 62							SB 11/05/16	
													

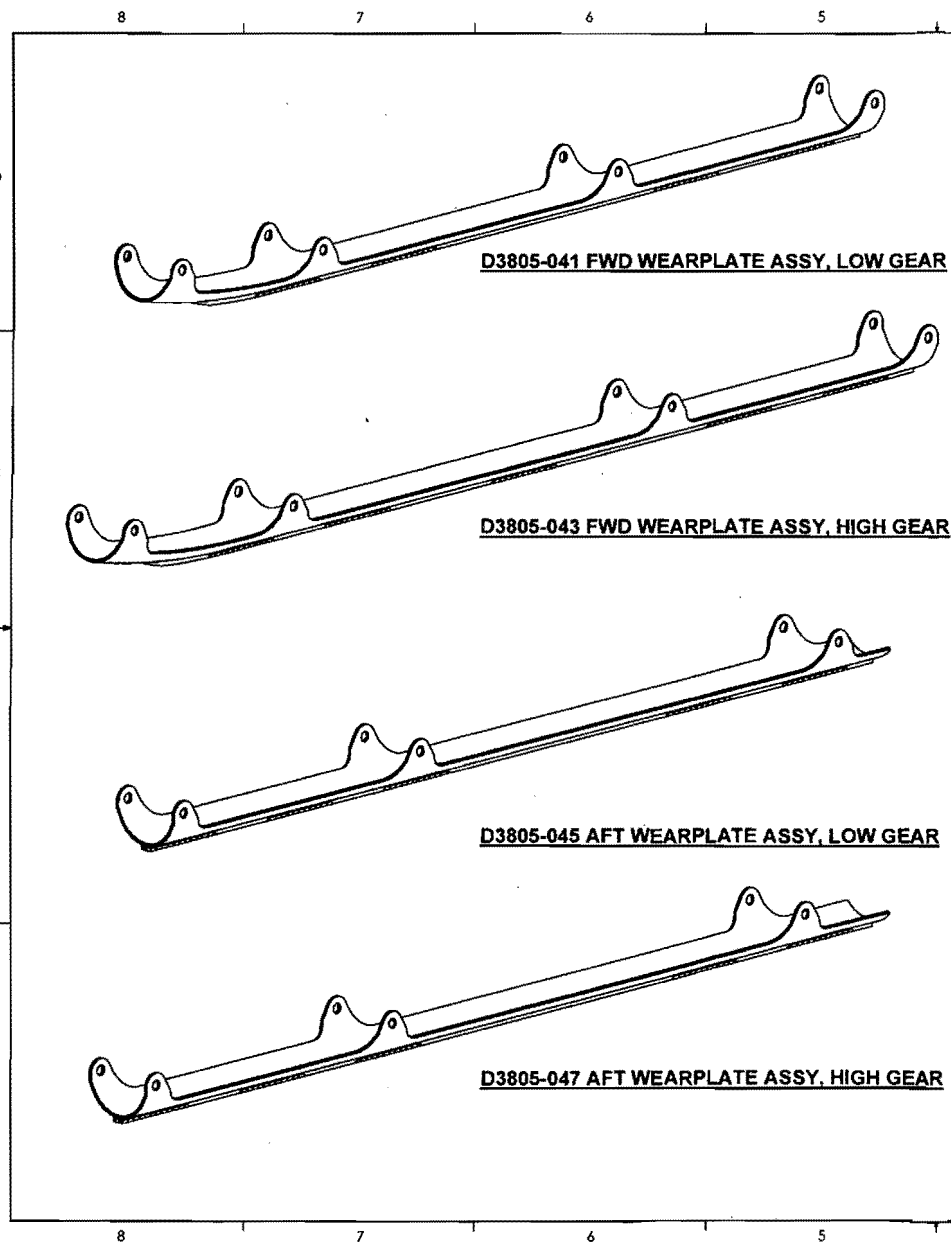
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ITEM	QTY -041	QTY -043	QTY -045	QTY -047	P/N	DESCRIPTION
1	X				D3805-041	FWD WEARPLATE ASSY, LOW GEAR
2		X			D3805-043	FWD WEARPLATE ASSY, HIGH GEAR
3			X		D3805-045	AFT WEARPLATE ASSY, LOW GEAR
4				X	D3805-047	AFT WEARPLATE ASSY, HIGH GEAR
11	1				D3805-1	PLATE
12		1			D3805-3	PLATE
13			1		D3805-5	PLATE
14				1	D3805-7	PLATE
15	1				D3806-1	BAR
16		1			D3806-3	BAR
17			1		D3806-5	BAR
18				1	D3806-7	BAR
19	1				D3807-1	GASKET
20		1			D3807-3	GASKET
21			1		D3807-5	GASKET
22				1	D3807-7	GASKET
31	A/R	A/R	A/R	A/R	2059B	HARDCOAT
32	A/R	A/R	A/R	A/R	1300 (OR 1300L)	3M SCOTCH-GRIP ADHESIVE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 64544
810-128

RELEASED
47 09 03 03
PR ECLN 09-538

A	NEW ISSUE	MB	08.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	JP	DART AEROSPACE USA, INC.	
DRAWN	JS	PORT HADLOCK, WA	
CHECKED	JS	DRAWING NO.	REV. A
MFG. APPR.	JS	D3805	SHEET 1 OF 8
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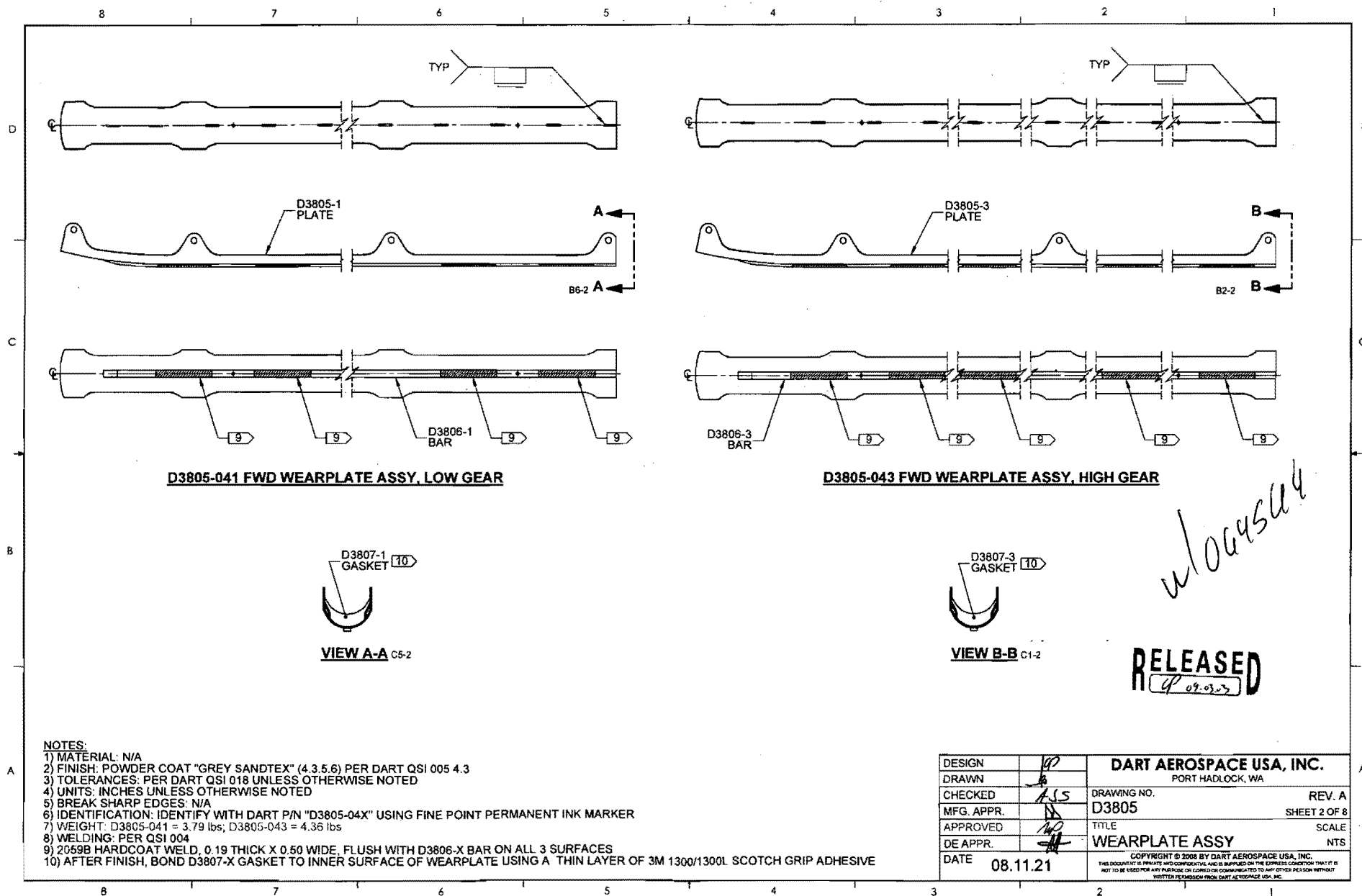
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NOTE: Date & initial all entries



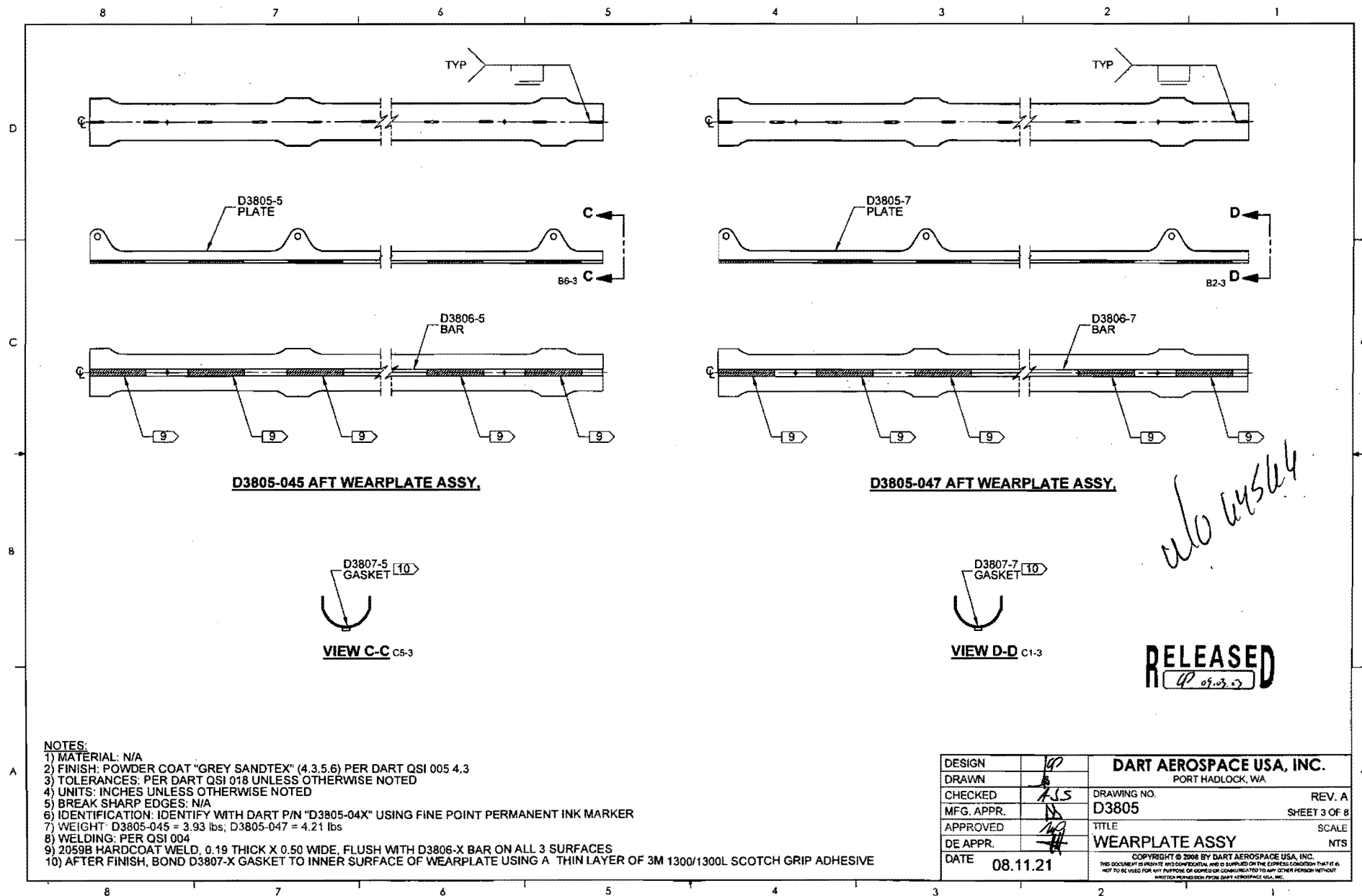
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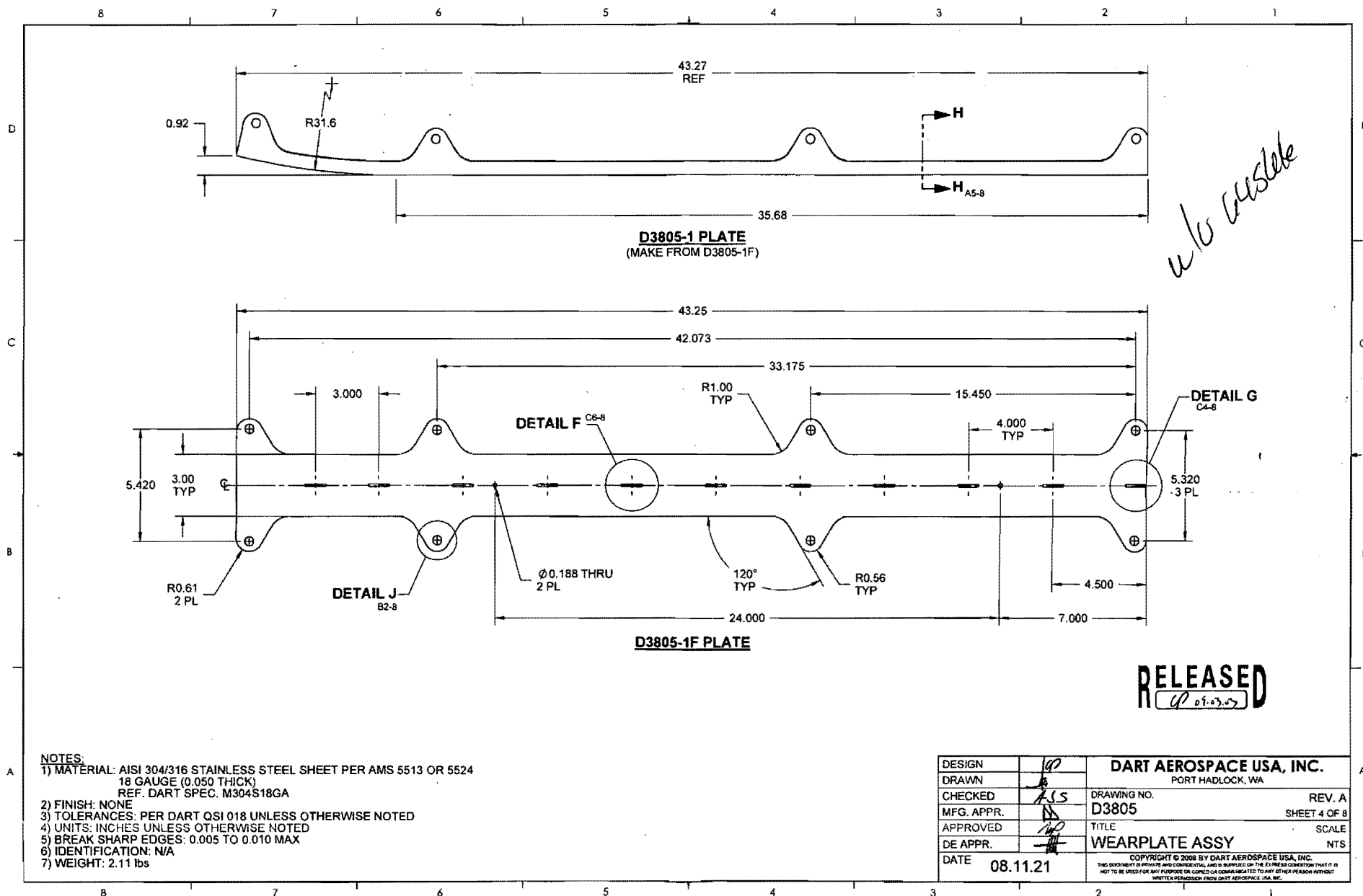
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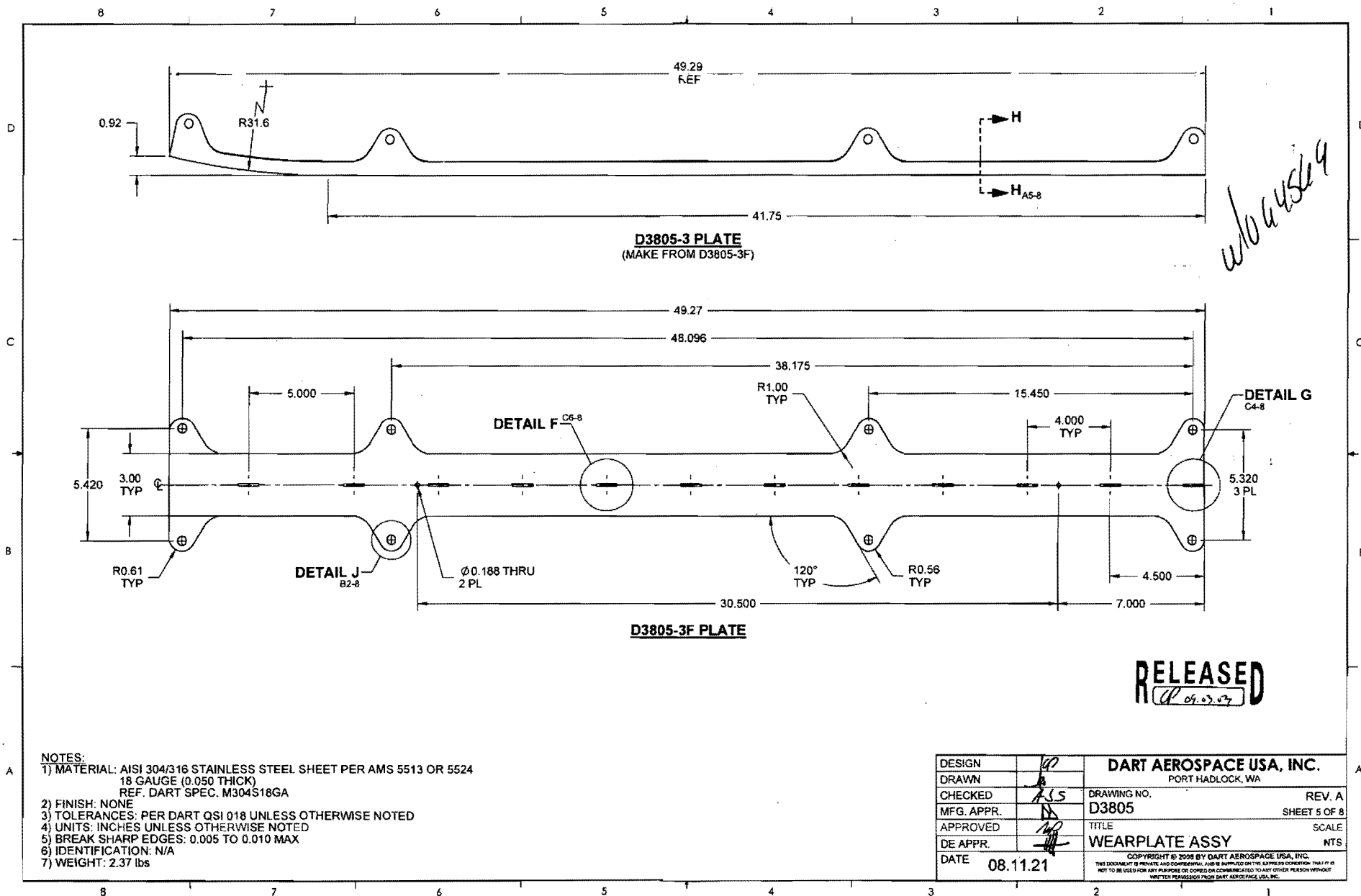
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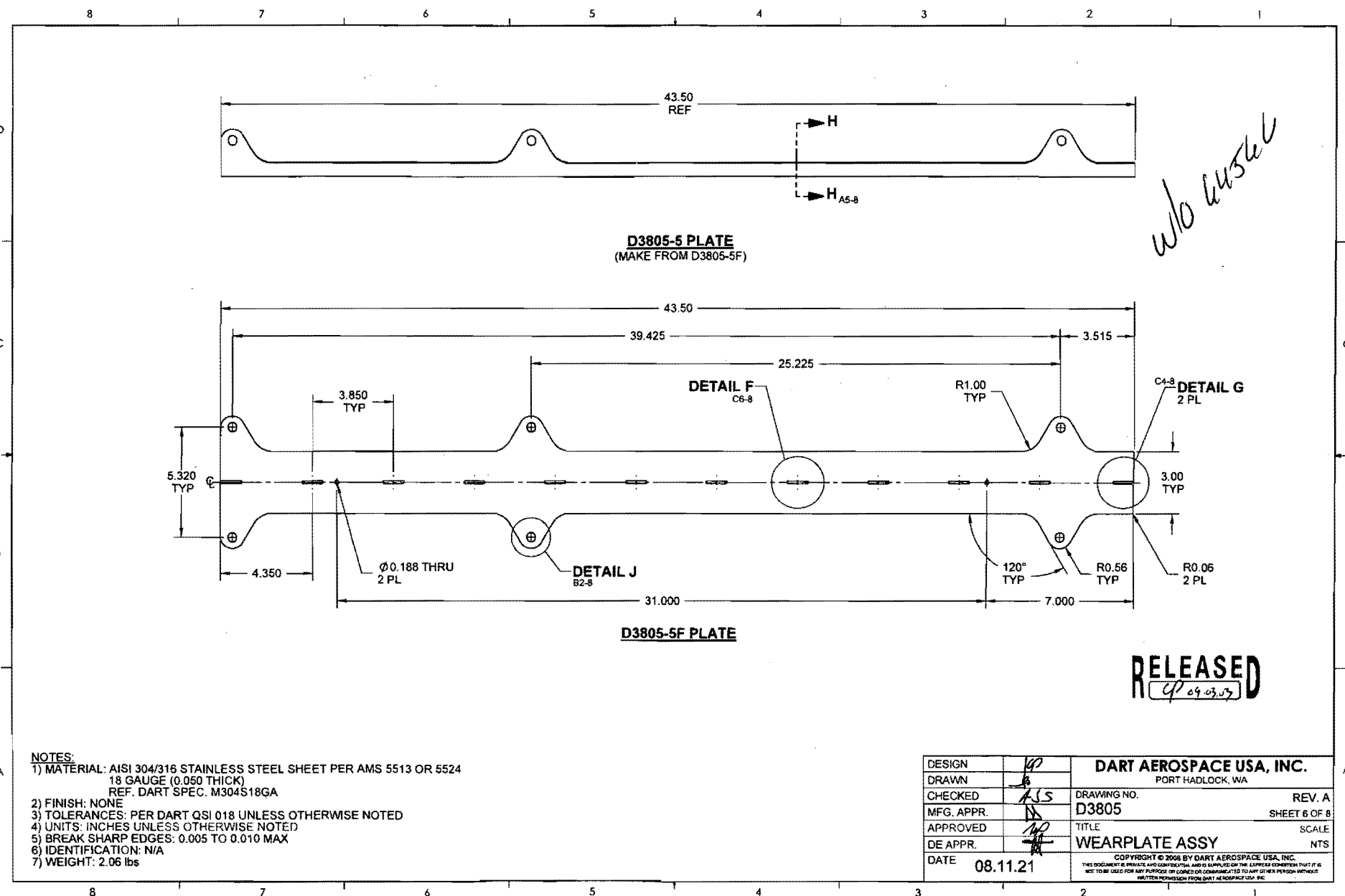
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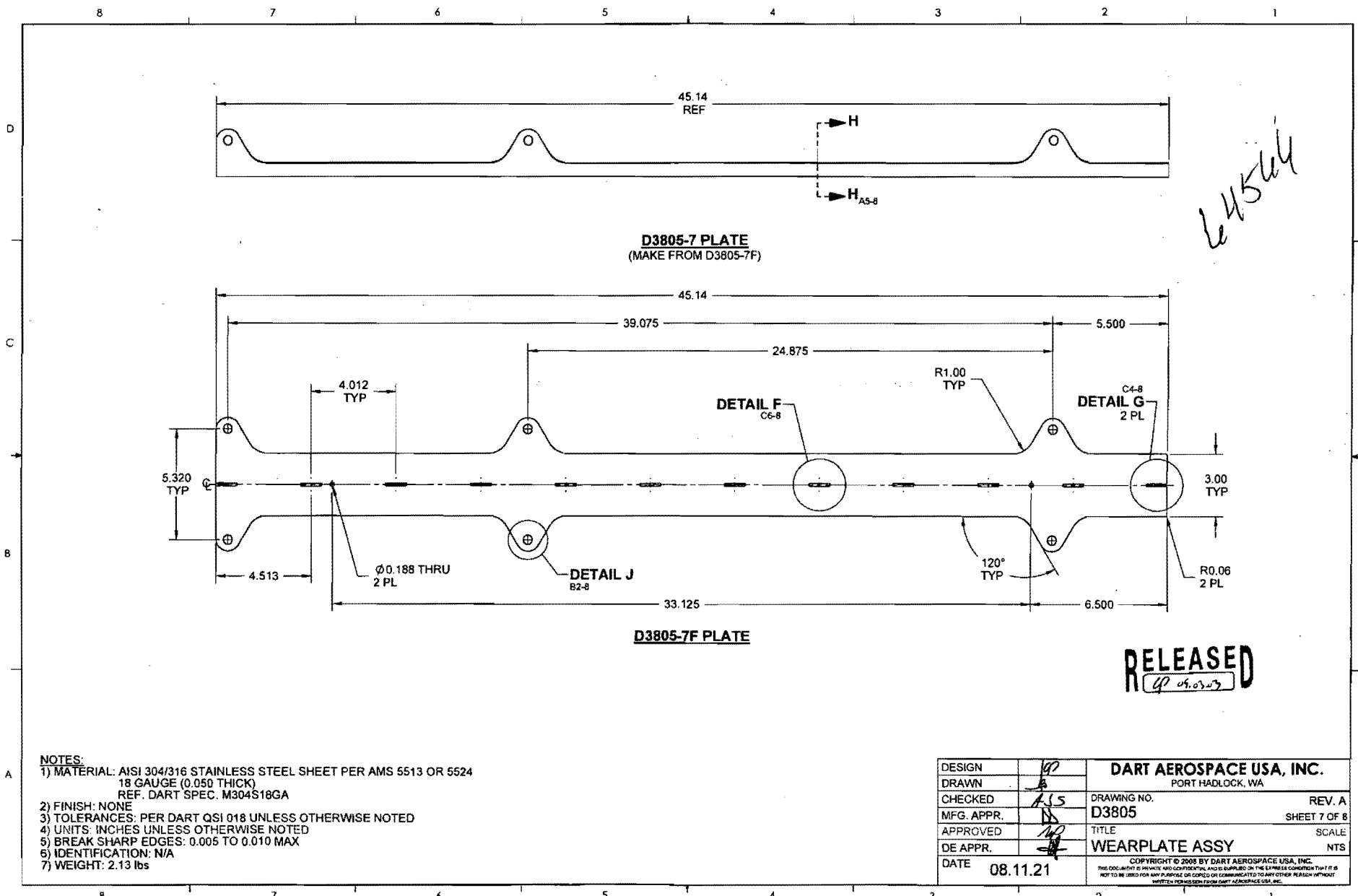
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- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE (0.050 THICK)
REF. DART SPEC. M304S18GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 2.13 lbs

DESIGN	107	DART AEROSPACE USA, INC.	
DRAWN	107	PORT HADLOCK, WA	
CHECKED	107	DRAWING NO.	REV. A
MFG. APPR.	107	D3805	SHEET 7 OF 8
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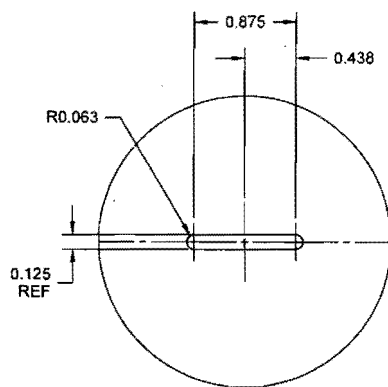
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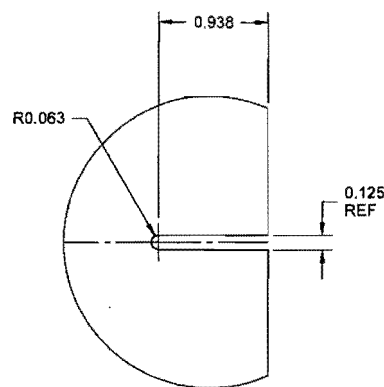
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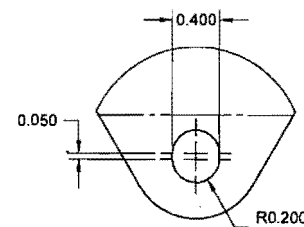
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SLOT DETAIL TYP
SCALE 4X

C5-4
C5-5
C4-6
C4-7



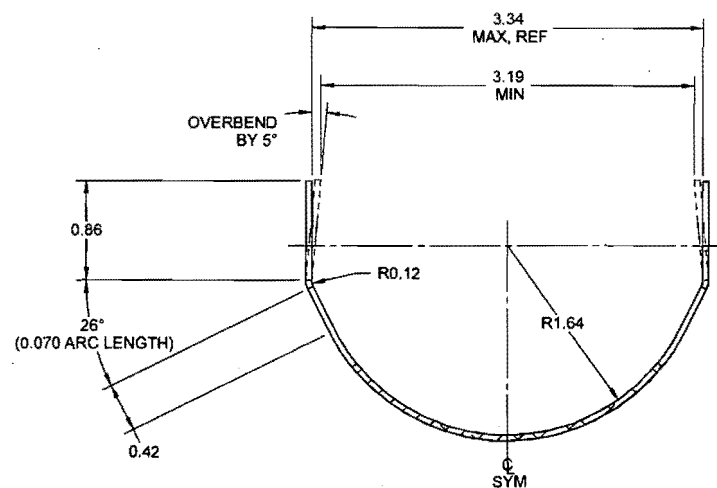
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SLOT DETAIL TYP
SCALE 4X

C1-4
C1-5
C1-6
C2-7



DETAIL J
SCALE 4X

B6-4
B7-5
B5-6
B5-7



SECTION H-H
SCALE 4X

D3-4
D3-5
D3-6
D3-7

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47-07-02-03

DESIGN	197	DART AEROSPACE USA, INC.	
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